

Date: Thursday, 5/3/2007 11:37:46 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : UPPER AND LOWER PLATE
 Job Number : 32193
 Estimate Number : 12837
 P.O. Number : N/A
 This Issue : 5/3/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : N/A
 Part Number : D35241
 Drawing Number : UNDER REVIEW C.B. 07.05.04
 Project Number : N/A
 Drawing Revision : N/A
 Material : N/A
 Due Date : 5/28/2007 Qty: 3 Um: Each
 Written By :
 Checked & Approved By : 07.05.04
 Comment : Est Rev:A New Issue 07-04-18 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0250X02000 6061-T6 Bar .25" X 2.0"



Comment: Qty.: 0.2100 f(s)/Unit Total: 0.6300 f(s)
 6061-T6 Bar .25" X 2.0"
 batch: M15949

07/05/05

3

2.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

07/05/05

3

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/05/05

3

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/05/05

3

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

07/05/14

3

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

07/05/15

3X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:37:46 AM
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Process Sheet

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Drawing Name: UPPER AND LOWER PLATE

Job Number: 32193

Part Number: D35241

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 07/15/16 (3)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/15/16 (3)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

EP 07/15/16

Job Completion



W 07-05-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

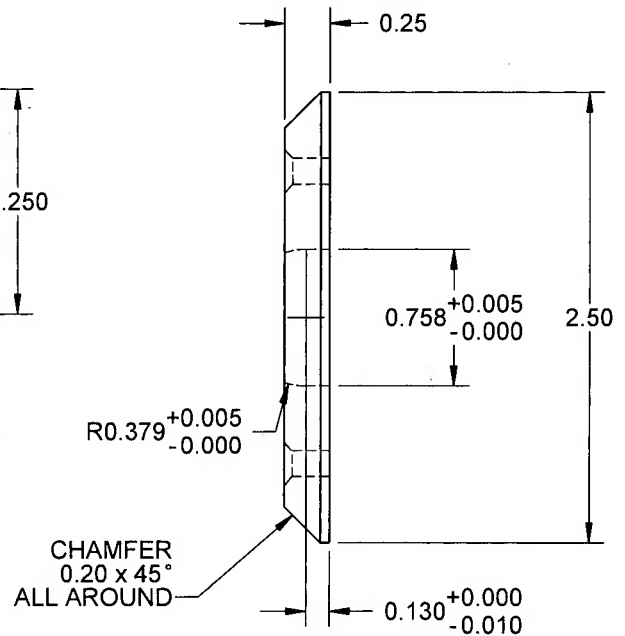
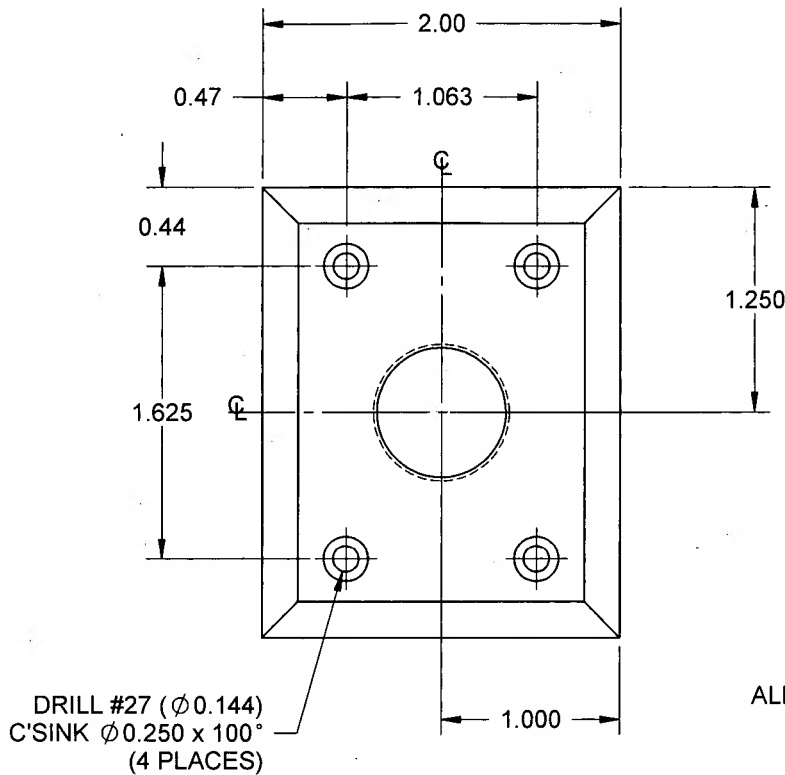
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3524	REV. A SHEET 1 OF 3
DATE 07.01.10	TITLE UPPER AND LOWER PLATE		SCALE 1:1
REV A	DATE 07.01.10	DESCRIPTION NEW ISSUE	

UNDER REVIEW
07.05.04 CB
dug not released



D3524-1 LOWER PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS-4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT ϕ

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 32193

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DART AEROSPACE LTD	Work Order: 32193
Description: LOWER PLATE	Part Number: D3524-1
Inspection Dwg: D3524 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	± 0.030	1.999	—			
1.250	± 0.016	1.250	—			
1.000	± 0.016	0.999	—			
Ø 0.144	± 0.004 ± 0.001	Ø 0.144	—			
Ø 0.250 X 100°	± 0.016	Ø 0.250 X 100°	—			
1.625	± 0.005	1.627	—			
0.44	± 0.030	0.441	—			
0.47	± 0.030	0.470	—			
1.063	± 0.005	1.063	—			
0.25	± 0.036	0.247	—			
2.50	± 0.036	2.500	—			
0.758	± 0.005 ± 0.000	0.763	—			
R 0.379	± 0.005 ± 0.000	R 0.379	—			
0.20 X 45°	± 0.036	0.203 X 45°	—			
0.130	± 0.000 ± 0.010	0.130	—			

Measured by: <i>gml</i>	Audited by: <i>br</i>	Prototype Approval:
Date: 07/05/05	Date: 07/05/05	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	